

Date: Tuesday, 7/1/2008 2:35:13 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 40202		
Estimate Number	: 10873		
P.O. Number	:	Part Number	: D32455
This Issue	: 7/1/2008 S.O. No. :	Drawing Number	: D3245 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 35667	Material	:
Written By	:	Due Date	: 7/1/2008
Checked & Approved By	:	Qty:	6 Um: Each
Comment	: Est. A 04.07.07 New issue KJ/JLM Est Rev:b ECN 1052 07-10-31 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S22GA	304/316 .032 Sheet
-----	-----------	--------------------



S.

MAT NOT PULLED



Comment: Qty.: 0.8442 sf(s)/Unit Total : 5.0652 sf(s)

304/316 .032 Sheet

Batch: 109023

LB 8-8-25

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3245

Dwg Rev: B

Prog Rev: B

LB 8-8-25



2-Deburr if necessary

LB 8-8-25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



LB 8-8-25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/08/06 (X9)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr if necessary

Form D3245-5 as per Dwg D3245 Identify as D3245-5

S 08/08/02



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 7/1/2008 2:35:13 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 40202

Part Number: D32455

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/09/02 (X2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5779

SS 08/09/03 (X2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 (X2)

Job Completion



MF 08-09-03

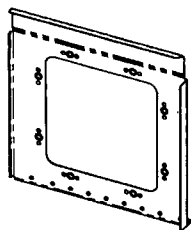
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

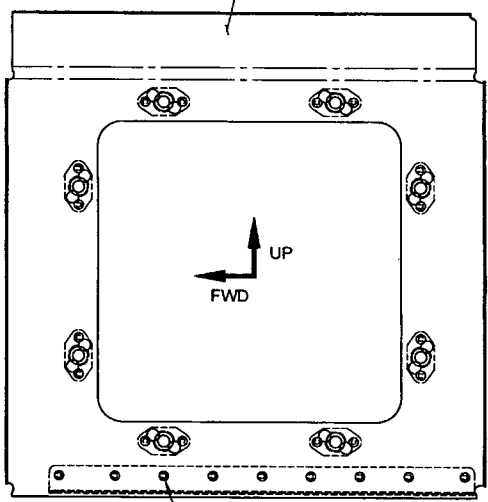
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

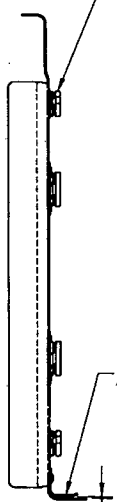


D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

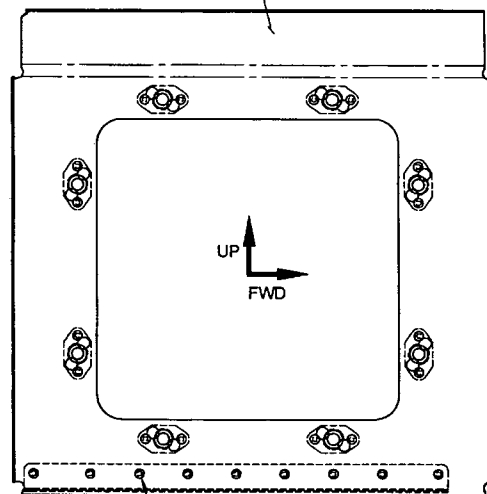
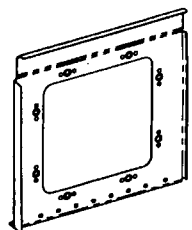


D3245-5  
ANGLE PLATE

0.032  
GAP

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

D3245-5  
ANGLE PLATE

0.032  
GAP

**D3245-041 ACCESS PANEL ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

**D3245-042 ACCESS PANEL ASSEMBLY**

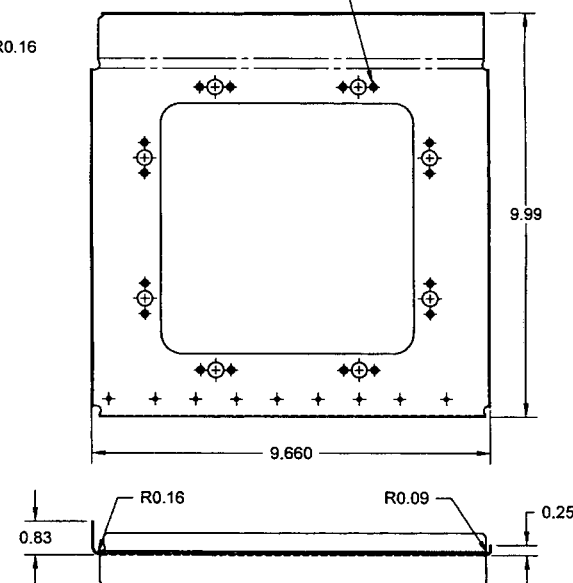
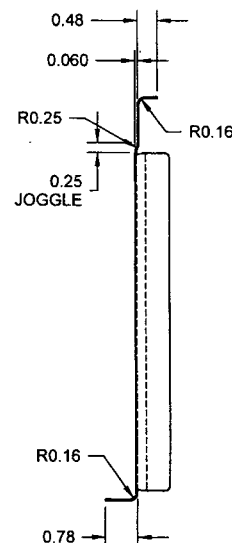
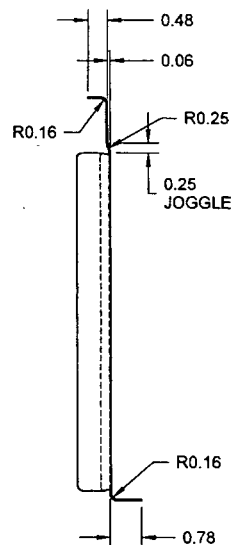
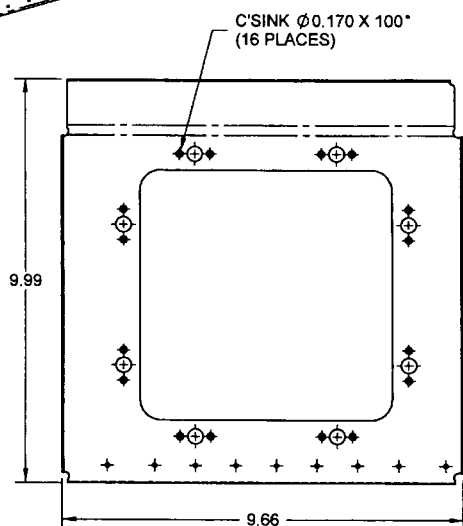
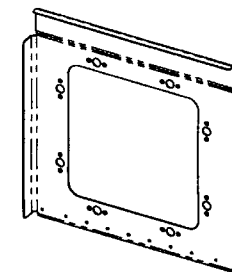
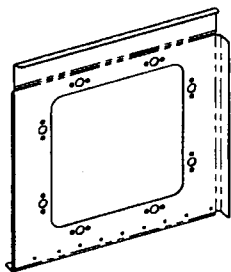
RELEASED  
17-10-23

- NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.83 lbs

NO. 10203  
 WORK ORDER  
 SUBJECT TO AMENDMENT  
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B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.02		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3245</b>	REV. B
TITLE <b>ACCESS PANEL ASSEMBLY</b>	SCALE 1:2.5
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D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED  
07-10-23

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

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SHOP COPY  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
WORK ORDER  
402-002

DESIGN	<del>TH</del>	DART AEROSPACE LTD	
DRAWN	<del>TH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>TH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>TH</del>	D3245	SHEET 2 OF 7
APPROVED	<del>TH</del>	TITLE	SCALE
DE APPR.	<del>TH</del>	ACCESS PANEL ASSEMBLY	1:3
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

D3245-7 GASKET  
(REF)

8.00  
(TYP, REF)

**D3245-043 DOOR ASSEMBLY**

INSTALL D3245-7  
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

**NOTES:**

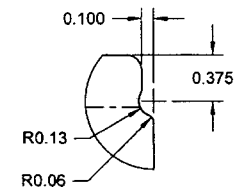
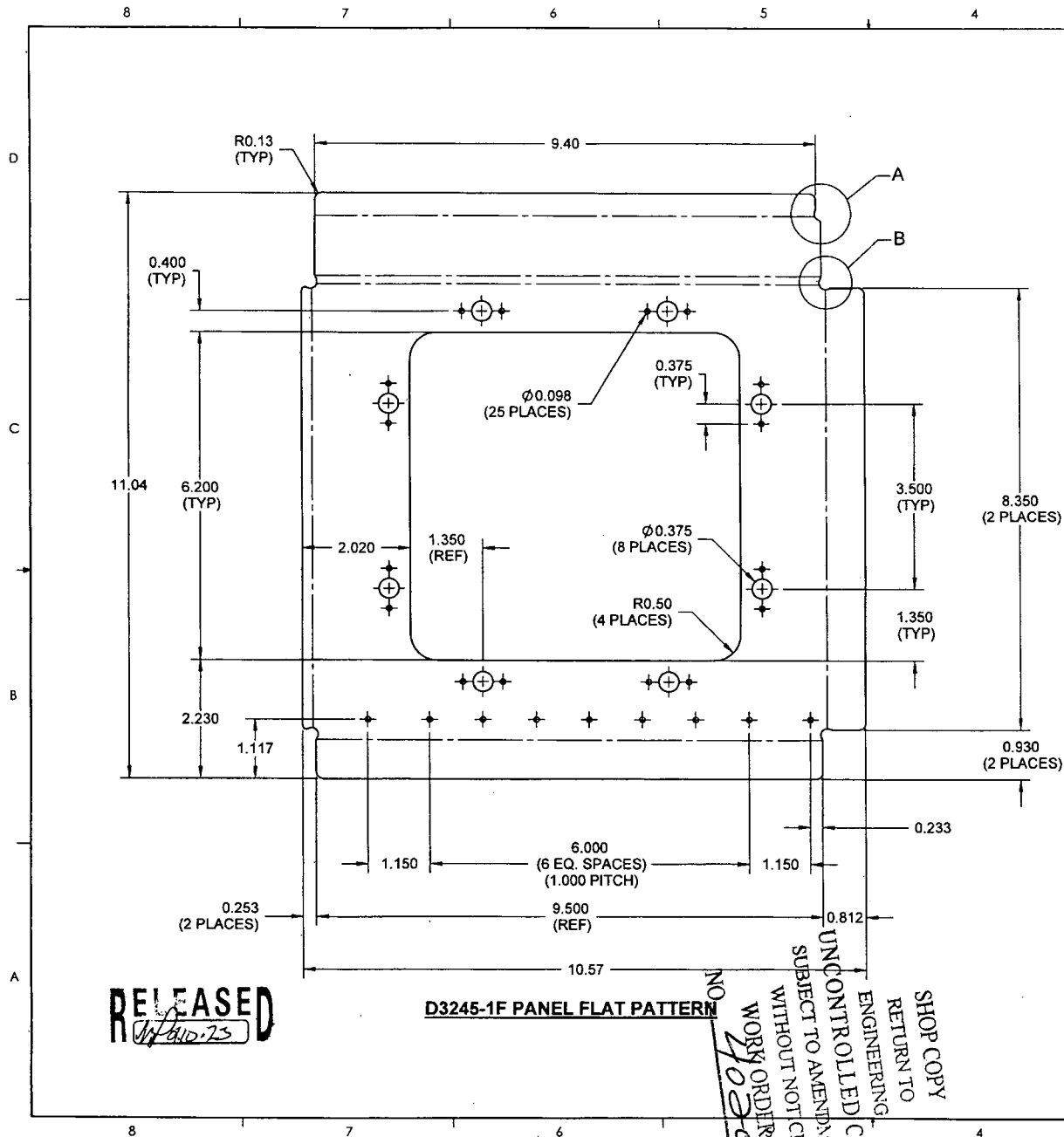
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

NO. 100000  
WORK ORDER  
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WITHOUT NOTICE

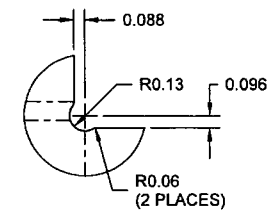
RELEASED  
27-JD-23

DESIGN	<del>PH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>PH</del>	D3245	SHEET 3 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	ACCESS PANEL ASSEMBLY	
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8 7 6 5 4 3 2 1



**DETAIL A: RELIEF**  
SCALE 1:1



**DETAIL B: RELIEF**  
(TYP. 4 PLACES)  
SCALE 1:1

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET  
(0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	#	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO.	REV. B
CHECKED	PH	<b>D3245</b>	SHEET 4 OF 7
MFG. APPR.	PH	TITLE	SCALE
APPROVED	PH	<b>ACCESS PANEL ASSEMBLY</b>	1:2
DE APPR.	PH	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

NO  
WORK ORDER  
100002  
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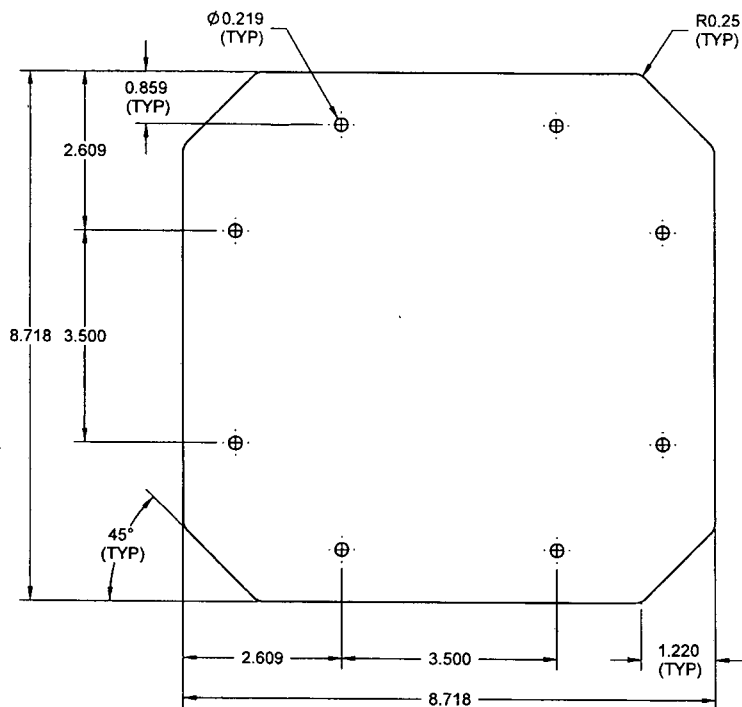
8 7 6 5 4 3 2 1

D

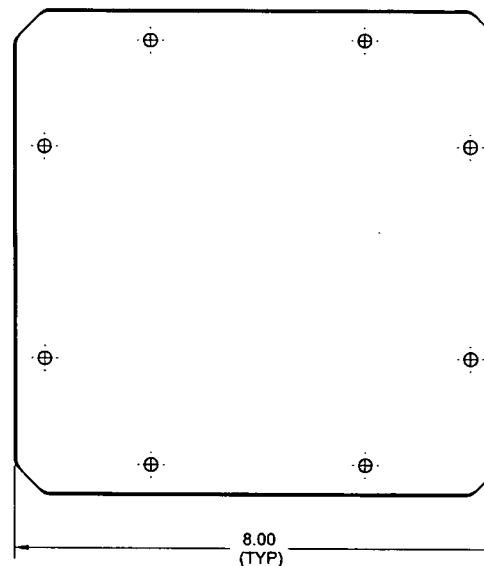
C

B

A



**D3245-3F DOOR FLAT PATTERN**



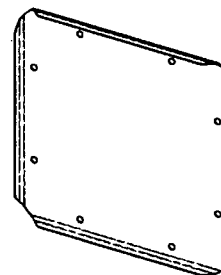
**D3245-3 DOOR BENDING DETAIL**

**RELEASED**  
07-10-02

NO. 10000  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
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RETURN TO  
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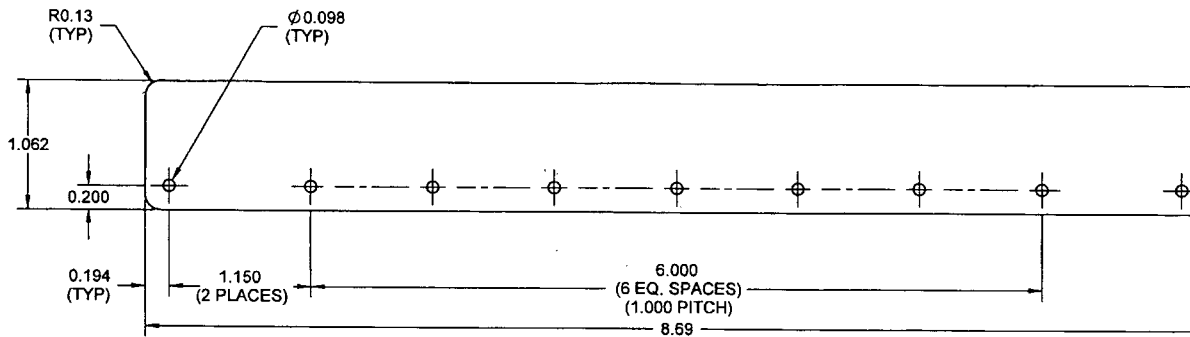
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

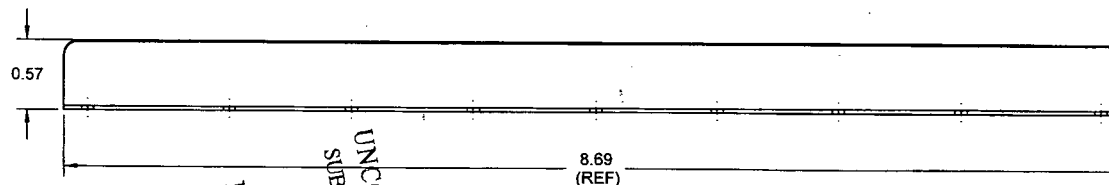


DESIGN	JH	<b>DART AEROSPACE LTD</b>	
DRAWN	JH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 5 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>ACCESS PANEL ASSEMBLY</b>	
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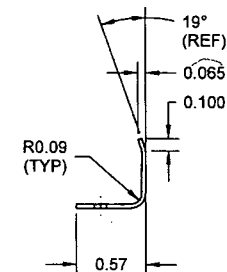
8 7 6 5 4 3 2 1



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL**  
(MAKE FROM D3245-5F)



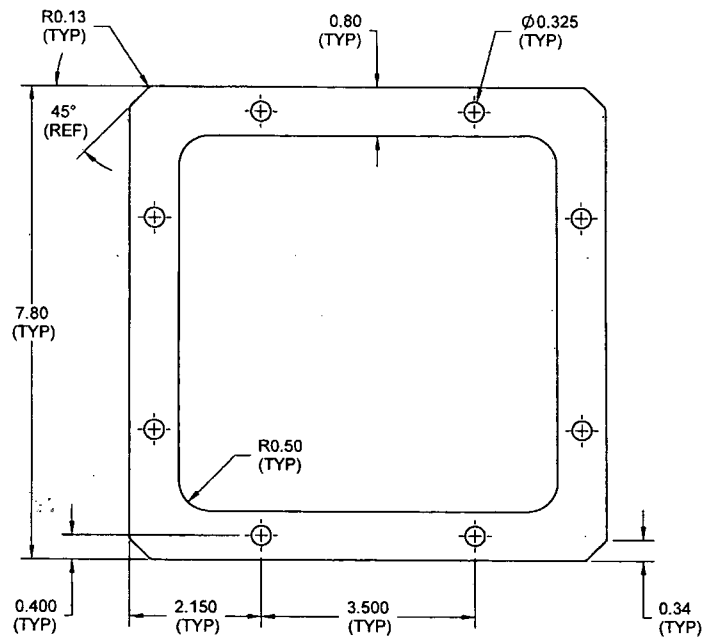
**RELEASED**  
07.10.02

**NOTES:**

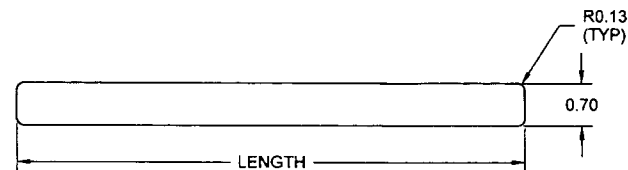
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

NO. 10202  
WORK ORDER  
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DESIGN	<b>D3245</b>	<b>DART AEROSPACE LTD</b>	
DRAWN	<b>PH</b>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<b>PH</b>	DRAWING NO.	REV. B
MFG. APPR.	<b>DS</b>	<b>D3245</b>	SHEET 6 OF 7
APPROVED	<b>PH</b>	TITLE	SCALE
DE APPR.	<b>PH</b>	<b>ACCESS PANEL ASSEMBLY</b>	1:1
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**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

NO. 4000  
WORK ORDER  
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DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3245</b>
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 7 OF 7
DE APPR.	<i>[Signature]</i>	TITLE <b>ACCESS PANEL ASSEMBLY</b>
DATE	<b>07.10.02</b>	SCALE 1:2

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